

Work Order ID 61793

Friday, September 03, 2010 1:40:18 PM



Page 1

Item ID:	D3927-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Guard					
Start Date:	9/3/2010	Start Qty: 4.00		Cust Item ID:		
Required Date:	9/7/2010	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>14</i>	Date:	<i>10-9-03</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3927	<i>AB</i>								
100		0.00							
Waterjet		0.00						<i>B(0-11-3)</i>	
FLOW CNC Waterjet									
DELRIN									
110		0.00							
HAAS 1		0.00							
HAAS CNC vertical machine #1									

1-Mill as per folio FA & dwg D,
FOLIO REV: *AA*
DWG REV: *B*

2-Deburr as required

SL 10/12/14

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval' QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3927-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guard

Start Date: 9/3/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

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QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

ant 10/12/14

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

10/12/15sf (52)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3927-1

Accept

Revision ID:

Item Name: Guard

Start Date: 9/3/2010 Start Qty: 4.00

Required Date: 9/7/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/15
MF
10-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61793



Parent Item: D3927-1



Parent Item Name: Guard

Start Date: 9/3/2010

Required Date: 9/7/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB1.000X04.0 00		Purchased	No			100	f	45.6000	1.36	5.726316			



Delrin Bar



1810-11-3

Location

Loc Qty

Loc Code

MAT050

45.6

111695

6

112665

39.6

112665

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

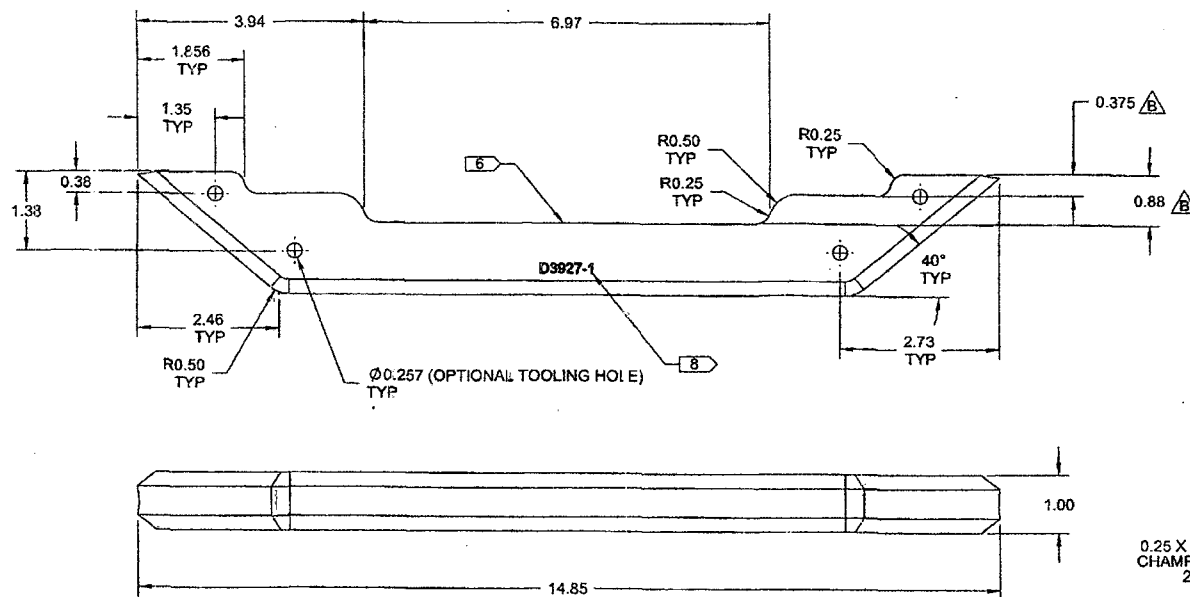
DART AEROSPACE LTD		Work Order:	
Description: Guard		Part Number:	D3927-1
Inspection Dwg: D3927 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/-0.030	1.377	✓		kn. 2-3	
0.38	+/-0.030	0.377	✓			
1.35	+/-0.030	X				
1.856	+/-0.010					
3.94	+/-0.030					
6.97	+/-0.030					
R0.50	+/-0.030	0.500	✓		R-G	
R0.25	+/-0.030	0.250	✓		R-G	
0.375	+/-0.010	0.375	✓			
0.88	+/-0.030	0.870	✓		H-G	
40°	+/-0.5°	40°	✓			
2.73	+/-0.030	2.721	✓		H-G	
14.85	+/-0.030	14.865	✓		H-G	
1.00	+/-0.030	1.040		✓		stock mat
2.13	+/-0.030	2.127	✓		H-G	
0.25 x 45°	+/-0.030 x 0.5°	0.245 x 45°	✓			
R1.58	+/-0.030	1.580	✓			

Measured by: <i>SL</i>	Audited by: <i>QML</i>	Preliminary Approval:
Date: 10/12/14	Date: 10/12/14	Date:

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	
B	10.11.05	Dimensions updated per Dwg Rev B	KJ <i>[Signature]</i>	<i>[Signature]</i>



D3927-1 GUARD

w/o 617A3

RELEASED
2010-09-15

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.0 THICK
PER DART SPEC M-DELIN-S1.0
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.59 lbs
- 8) ENGRAVE "D3927-1" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015±0.005 AT LOCATION INDICATED

B	REDESIGN: 2.13 WAS 3.25 (C2-1), ADD RELIEF (D3-1), 0.88 WAS 1.13 (D3-1), RMV "NO STEP" TEXT, 10.71 WAS 10.00 (C5-2), 34" WAS 21" (C2-1), ADD OSROUNDS (B2-2)	CP	10.08.22
A	NEW ISSUE	BY	08.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	90		
CHECKED	90		
MFG. APPR.	90		
APPROVED	90		
DE APPR.	90		
DATE	10.08.22		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO.		REV. B	
D3927		SHEET 1 OF 2	
TITLE		SCALE	
GUARD		NTS	
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